

Date: Thursday, 6/15/2006 1:41:27 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 27557		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 6/15/2006 S.O. No. : N/A	Drawing Number	: D2577 REV-E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 24199	Material	: N/A
Written By	Signature: [Signature] Comment (below) Due Date : 6/30/2006 Qty: 50 Um: Each		
Checked & Approved By	Signature: [Signature] 06-06-15 JLM		
Comment	Est: F 02.09.24 Re-format: KJ/RF Est Rev:D Now on Waterjet: 06-06-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 1.0301 sf(s)/Unit Total : 51.5025 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: M100473(22) M100473		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: C Prog Rev: E		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.08.08	2.0	IP Part SCRAP. The hole was key out of tolerance, from Water Jet.	QP 06.08.08 per QSI 042	<del>Re-drill hole.</del> Use wear plate for weld test.	SAD 06.09.08 per QSI 042	2 06.09.08	QP 06.08.09 per QSI 042	06.08.08

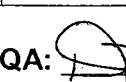
Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA: 

Date: 06/08/09

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:41:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27557

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

33

SAN 06/07/19

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/07/31

DL

33

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/07/31

33

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DL 06/07/31

33

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/09

33

Job Completion



h 06/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

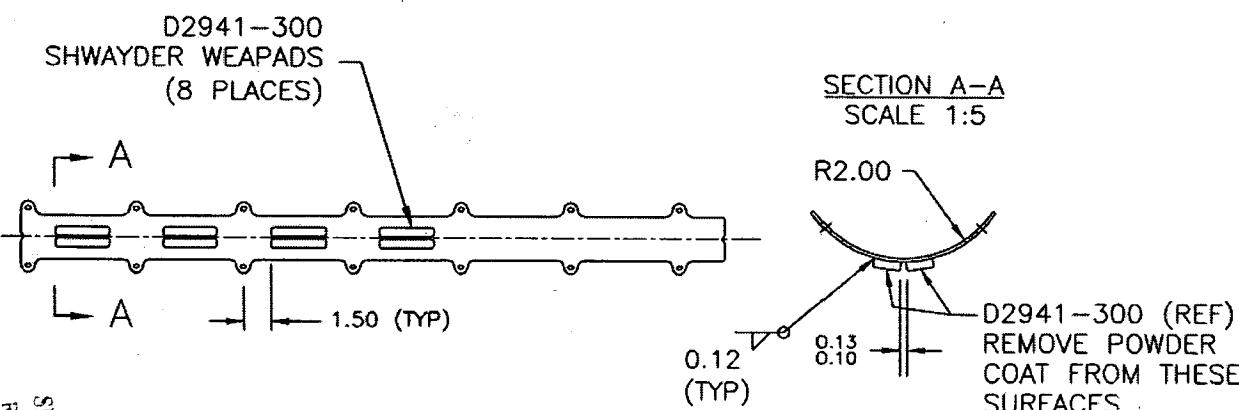
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WORK ORDER

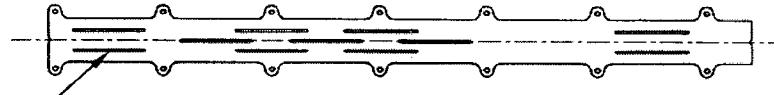
WITHOUT NOTICE



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED	APPROVED	REV. E
	D2577	SHEET 1 OF 5
00.09.22	WEARSHOE	SCALE
A	96.09.16	1:10
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

**RELEASED**

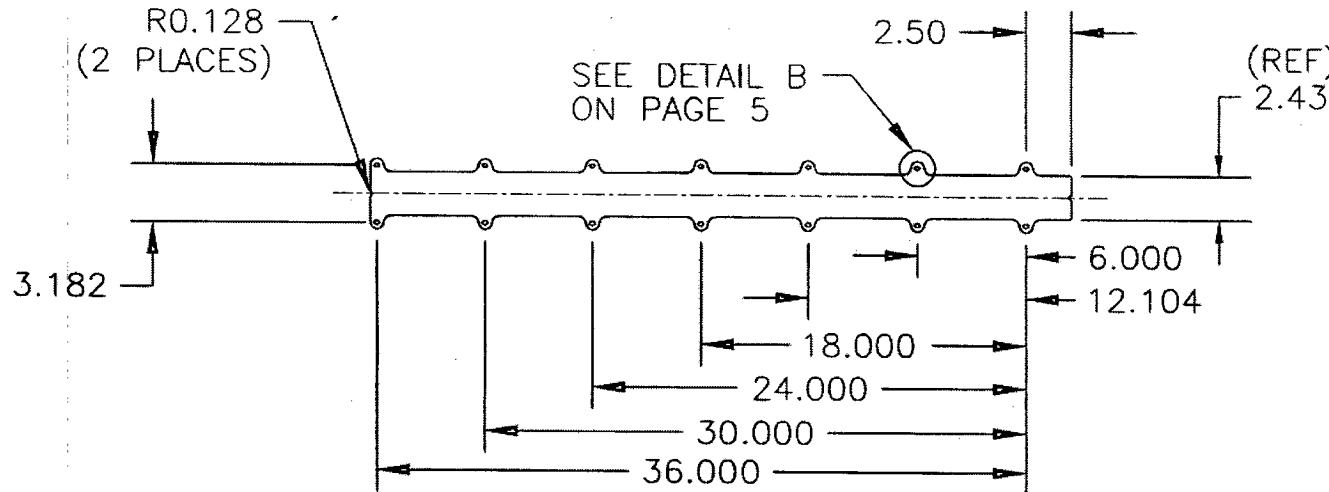
Rev. E  
04.26.97

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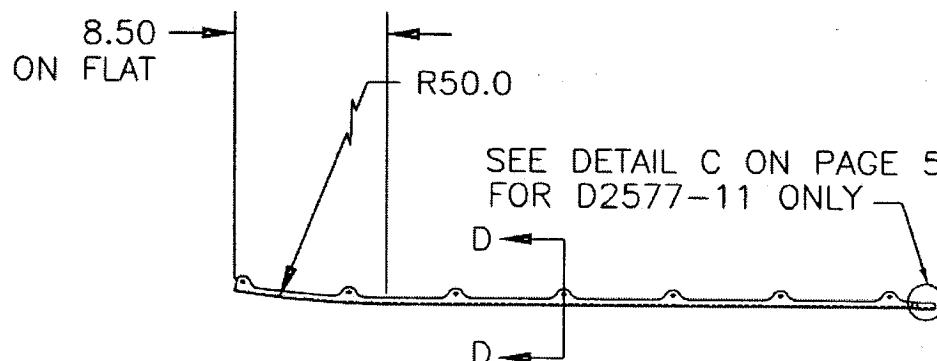


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

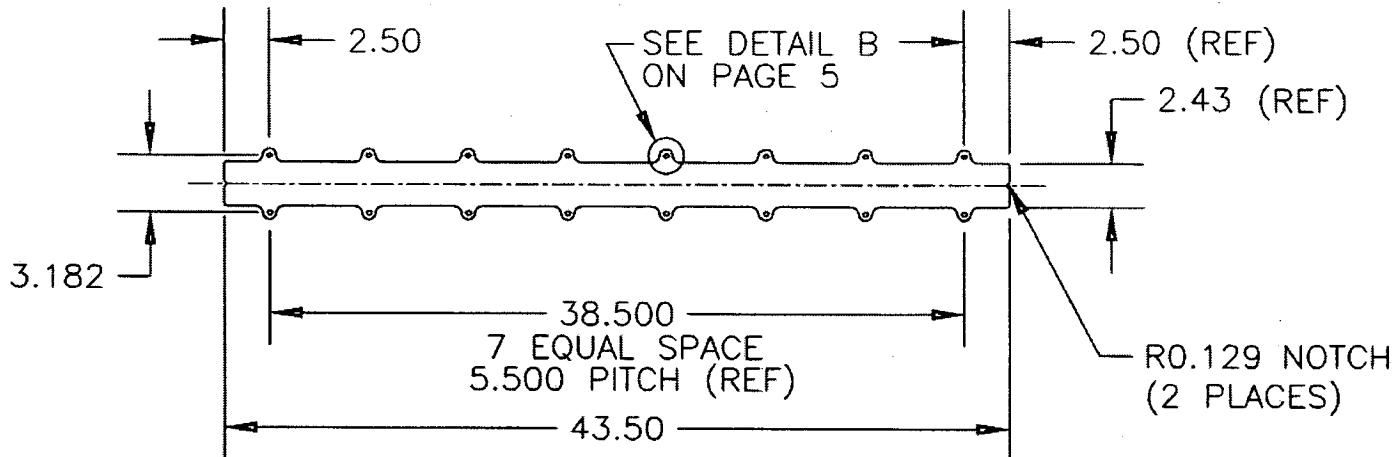
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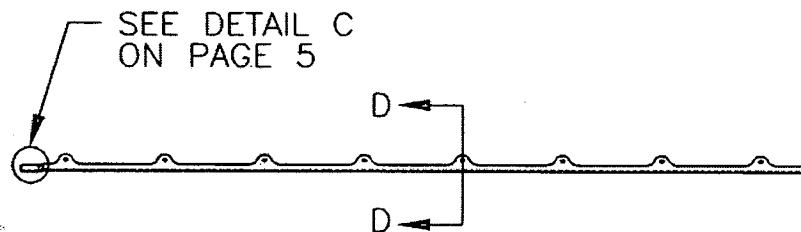
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		D2577
DATE	TITLE	SHEET 2 OF 5
00.09.22	WEARSHOE	SCALE
		1:10

**RELEASED**  
08.01.26

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	00.09.22	SHEET 3 OF 5 SCALE 1:10

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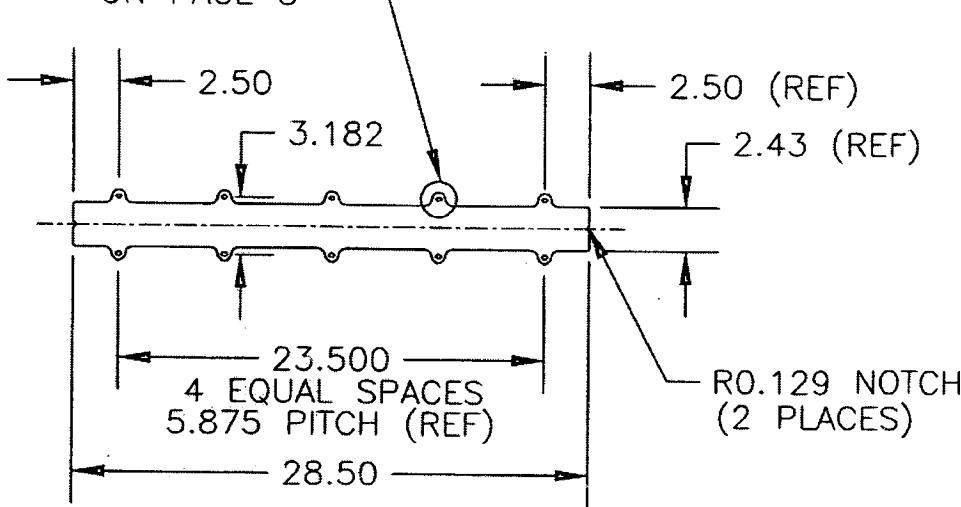


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00.09.22		SCALE 1:10
		TITLE WEARSHOE

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00.09.26

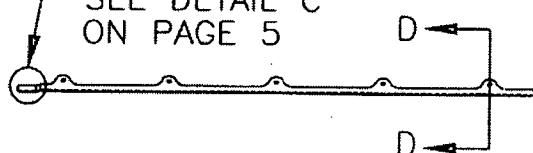
### D2577-7 FLAT PATTERN

SEE DETAIL B  
ON PAGE 5



### D2577-7 LONGITUDINAL BEND

SEE DETAIL C  
ON PAGE 5



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
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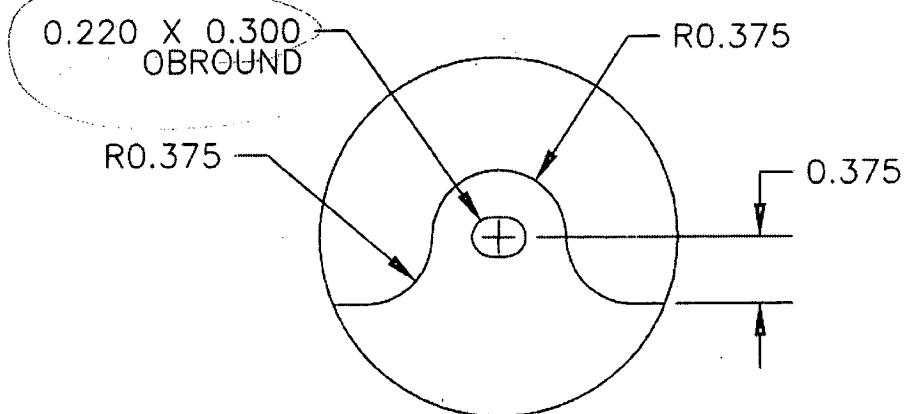


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SERIAL

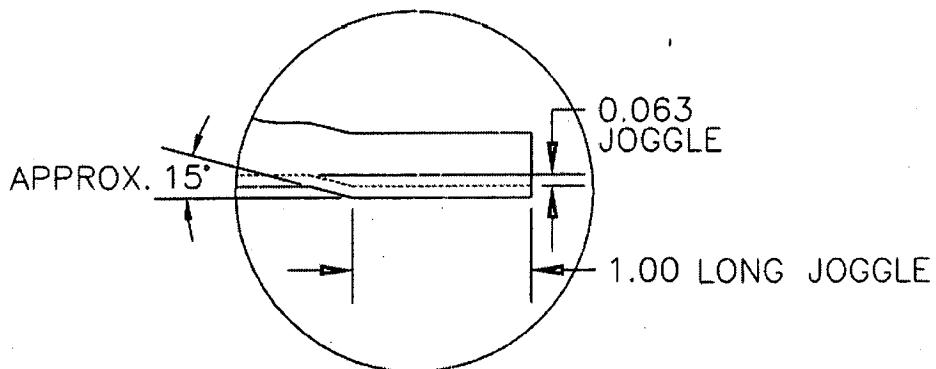
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		D2577	SHEET 5 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10

DETAIL B (SCALE 1:1)

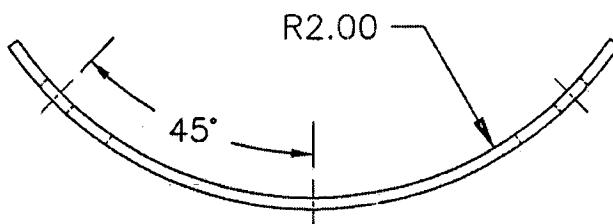
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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WORK ORDER  
NO. 22557

DART AEROSPACE LTD	Work Order:	27557
Description:	Part Number:	D2575
Inspection Dwg: , Rev:	Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:	SAP	Audited by:		Prototype Approval:	
Date:	06.06.27	Date:	17-07-18	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	